

5/27

SPLIT

DART AEROSPACE LTD	Work Order:	23677
Description: Angle Bracket	Part Number:	D3258-1
Dwg: D3258 Rev. A	Qty:	9 <del>10</del>
Ref:		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	KJ	05.06.27	10
2	PG	Issue P/O: <u>7008249</u> Email or Ship DXF file to vendor Laser Cut D3258-1 as per Dwg D3258 Material release note is required	UL	05.06.28	10
3	RG	Receive and Inspect for transit damage Ensure material release note is attached	DL	05/07/28	10
4	QC6	Inspect dimensions as per Dwg D3258	2	05-08-17	10
5	GA	Deburr if necessary	SAD	05/08/17	10
6	ST	Identify and Stock <u>1.60</u>	CL	05/08/17	10
7	AC	Cost / part <u>23,11</u>	SC	05-10-26	9
8	DC	Close W/O <u>23,11</u> Inspect Level 21	KJ	05/10/26	9

Rev	Date	Change	Revised By	Approved
A	04.04.15	New issue	KJ/RF	RF

5b	GA	Form per dwg D3258
5c	QC5	Inspect

(SB 05/08/23 9) PTO  
 RELEASED  
 14/04/05-06  
 2 05-08-24 9

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
05/08/23	5B SC	Permanent change ≥ shown on drawing			u	05/08/23		le	2 05-08-24
						✓ 05/10/23			

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector	
			Initial Design Mgr	Action Description Design Mgr	Sign & Date				
05/08/23	5B	1 piece was over bend	SD 05/08/23	Scrap + destroy	SD 05/08/23	✓ 05/08/23	SD 05/08/23	SD 05/08/23	SD 05/08/23

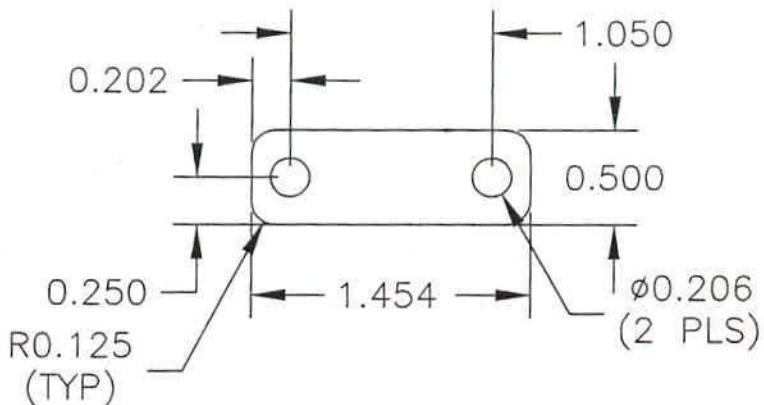
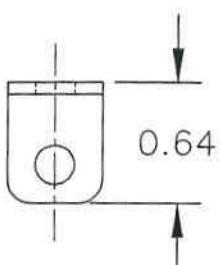
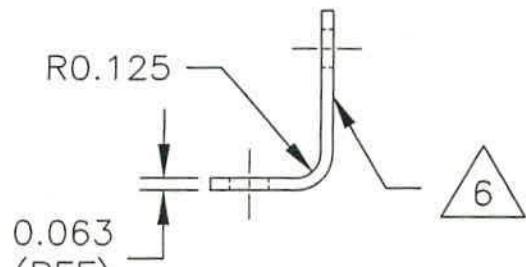
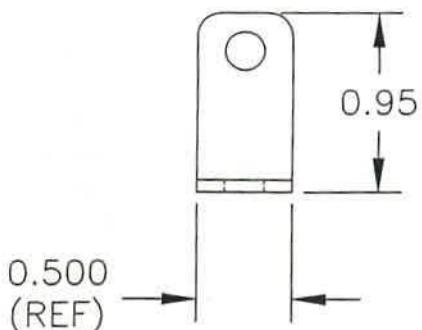
Part No: D3258-1 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes C No D DQA: D Date: 05/10/23  
 NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

**DART**OACOPY ISSUE  
DE

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED H	APPROVED H	DRAWING NO. D3258
DATE 04.01.27		TITLE ANGLE BRACKET
		SCALE 1:1

A 04.01.27 NEW ISSUE

**RELEASED**  
04.04.05D3258-1 FLAT PATTERND3258-1 ANGLE BRACKETNOTES:

- 1) BREAK ALL SHARP EDGES 0.005 to 0.015
- 2) MATERIAL: AISI 304/316 SS 0.063 (16 GAUGE) THICK (REF. DART SPEC. M304S16GA)
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) ENGRAVE DART P/N AS SHOWN

SHOP COPY

RETURN TO  
ENGINEERINGUNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICEWORK ORDER  
NO. Z3677

## Job Costing Report

Dart Aerospace Ltd.  
HawkesburyJun 27, 2005  
08:10 am

Work Order No : 0023677  
 Project Name : D3258-1  
 Project For : WK527  
 Work Order Type : Main  
 Main WO Number :  
 House Part Number : D3258-1  
 Description : Angle Bracket  
 Manufactured : Yes  
 Amount Req'd : 5  
 Amount Done : 0  
 Start Date : 06-27-05  
 Est Finish Date : 07-05-05  
 Act Finish Date :  
 Drawings Reqd : No  
 Ok for Approval :  
 Approval Rec'd :  
 Department Code:  
 Burden Flags : NNNNNNN  
 WO Status : Open  
 Invoice State : Not Invoiced  
 Invoice Date :  
 Invoice Number :  
 Invoice Amount : 0.00  
 Order Entry No :  
 OE Value : 0.00  
 Est Mark Up : 0.000%  
 Actual Mark Up : 0.000%  
 \$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
=====		=====	=====		
Burden :	0.00	0.00	0.00		
=====		=====	=====		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/ (Loss) :	0.00	0.00

YIEH MAU CORP.  
燁茂實業股份有限公司

INSPECTION CERTIFICATE  
MATERIAL TEST/INSPECTION CERTIFICATES

9023922

INVOICE NO. : F03MB57  
COMMODITY : PRIME COLD ROLLED STAINLESS STEEL SHEET AISI 304, NO.4 (SIC)  
FINISH, WITH 100 MIC.FILM ON MAIN SIDE, WITH BACK-PASS,  
SLITTED EDGE. AISI 304, 2B FINISH, WITH PAPER INTERLEAVED,  
SLITTED EDGE.  
SPECIFICATION : AISI 304  
CUSTOMER : INTEGRIS METALS LTD

工廠:高雄縣路竹鄉順安路345號  
345, SHUN AN RD. LU CHU HSIANG  
KAOHSIUNG TAIWAN R.O.C.  
TEL:(07)6972885 FAX:(07)6973006  
CERTIFICATE NO:9212243  
DATE OF ISSUE:12/31/2003

(ITEM NO) SIZE	NO.	Weight (N.W.)		Heat No.	ID NO.	Physical Properties					Chemical Composition (%)							
						Tensile Test GL=50 m/m												
		KGS	LBS			Y.S. (N/mm <sup>2</sup> )	T.S. (N/mm <sup>2</sup> )	E.L. (%)	HRB	H V	C x100	Si x100	Mn x100	P x1000	S x1000	Ni x100	Cr x100	N x100
AISI 304 2B (7425-4228)																		
24GA/48"X120" (7425-8401)	1	1,442	3,179	YU129992	2AS68986C-1	281	687	56	81	157	4.6	50	110	26	4	804	1819	3.1
20GA/48"X120" (7426-2619)	1	1,446	3,188	YU226021	29S65042BA-21	293	636	58	81	157	4.4	55	115	31	4	808	1808	3.6
18GA/48"X120" (7426-5059)	1	1,428	3,148	YU226201	2AS68982B-21	303	672	56	83	165	4.2	52	115	23	2	814	1824	3.8
16GA/48"X96" (7426-5059)	1	1,414	3,117	YU225206	2AS68037-21	301	675	55	81	158	5.5	60	106	26	3	826	1818	2.2
16GA/48"X96" (7426-5059)	1	1,412	3,113	YU225206	2AS68037-22	301	675	55	81	158	5.5	60	106	26	3	826	1818	2.2
16GA/48"X96" (7426-5166)	1	1,413	3,115	YU225206	2AS68037-23	301	675	55	81	158	5.5	60	106	26	3	826	1818	2.2
16GA/48"X120" (7426-5455)	1	1,385	3,053	YU225390	2AS67026B-1	306	694	50	83	163	5	52	104	23	4	806	1816	2.7
16GA/48"X120" (7426-5455)	1	1,385	3,053	YU225390	2AS67026B-2	306	694	50	83	163	5	52	104	23	4	806	1816	2.7
16GA/48"X120" (7426-5455)	1	1,215	2,679	YU225390	2AS67026B-3	306	694	50	83	163	5	52	104	23	4	806	1816	2.7
16GA/60"X96" (7426-5497)	1	1,438	3,170	YU226508	2BS69861A-23	306	687	52	82	160	3.8	50	109	29	6	808	1809	2.6
16GA/60"X120" (7426-5612)	1	1,411	3,111	YU226508	2BS69861A-22	306	687	52	82	160	3.8	50	109	29	6	808	1809	2.6
16GA/60"X144" (7426-7949)	1	1,434	3,161	YU226508	2BS69861A-21	306	687	52	82	160	3.8	50	109	29	6	808	1809	2.6
14GA/48"X96" (7426-8053)	1	1,432	3,157	YU130016	2AS68134B-2	304	640	50	83	163	4.8	52	112	26	4	812	1816	2.8
14GA/48"X96" (7426-8053)	1	1,432	3,157	YU130016	2AS68134B-3	304	640	50	83	163	4.8	52	112	26	4	812	1816	2.8
14GA/48"X120" (7426-8160)	1	1,435	3,164	YU225138	2AS68038B-1	303	661	50	83	163	4.6	45	104	22	8	812	1805	2.6
14GA/48"X120" (7426-8160)	1	1,437	3,168	YU225138	2AS68038B-2	303	661	50	83	163	4.6	45	104	22	8	812	1805	2.6
14GA/48"X144" (7426-8244)	1	1,425	3,142	YU130016	2AS68038B-3	302	661	50	83	163	4.6	45	104	22	8	812	1816	2.8
14GA/60"X96" (7426-8244)	1	1,413	3,115	YU130125												810	1808	3.6
	19	26,834	59,158															

Remarks: NO MERCURY CONTAMINATION  
WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS  
BEEN MADE IN ACCORDANCE WITH THE RULES OF THE CONTRACT.

ICE WITH ASTM A240, A480,  
766D.

YIEH MAU CORP.

*[Signature]*  
Manager of Quality Assurance Section

16ga 304 2B



New Zealand Steel Limited  
Glenbrook, South Auckland  
Postal: Private Bag 32125, Auckland, New Zealand  
Telephone: (09) 375 8999 / 375 8111 Auckland  
(06) 235 5088 / 235 3636 Waikato  
Fax: (09) 375 9959

## TEST CERTIFICATE

Ref. 4717/2005

CUSTOMER Wilkinson  
CUSTOMER IDN 90-31N-294  
MILL IDN 453750

P41006MEO03

SPECIFICATION ASTM A1011 CS Type B

CERTIFICATE No TC101993

PRODUCT HOT ROLLED PICKLED & OILED

PAGE 1 of 1

DIMENSIONS 0.104" x 48" x Coil 12 GA M.S.

DATE 29 December 2004

PACK NUMBER	HEAT No	CHEMICAL COMPOSITION PERCENT										MECHANICAL TESTS (TEST SPECIFICATION - ASTM A370)											
		C	S	Mn	P	S	Cr	Ni	Mo	V	Nb	Ti	N	B	N2	CE	BEND	YIELD	T.S.	%ELONG	HARDNESS	R	
		x100				x100				x100			x100	x10000	x100	180°						( )	/mt
HP-942195-00	638407	5	TR	20	15	19	12	18	18	1	7	1	1				Good					955	
HP-942196-00	638407	5	TR	20	15	19	12	18	18	1	7	1	1				Good					955	
HP-942197-00	638406	5	TR	20	14	19	12	18	17	2	6	1	1				Good					955	
HP-942198-00	638406	5	TR	20	14	19	12	18	17	2	6	1	1				Good					955	
HP-942200-00	638407	5	TR	20	15	19	12	18	18	1	7	1	1				Good					955	
HP-942201-00	638406	5	TR	20	14	19	12	18	17	2	6	1	1				Good					955	
HP-942202-00	638406	5	TR	20	14	19	12	18	17	2	6	1	1				Good					955	
HP-942203-00	638406	5	TR	20	14	19	12	18	17	2	6	1	1				Good					955	
HP-942204-00	638406	5	TR	20	14	19	12	18	17	2	6	1	1				Good					955	
HP-942205-00	638406	5	TR	20	14	19	12	18	17	2	6	1	1				Good					889	
HP-942206-00	638406	5	TR	20	14	19	12	18	17	2	6	1	1				Good					955	
																						951	

YIELD	GAUGE LENGTH (G.L.)		PLASTIC STRAIN RATIO (I)				IMPACT TEST		CARBON EQUIVALENT VALUE (CE)	
(A)=0.2% PROOF STRESS	(A)=20mm		(E)=2"				(A)=0		(C)=45	
(B)=LOWER YIELD STRESS	(B)=50mm		(E)=0.65 x 50				(C)=5mm x 5mm		(D)=C+Mn/6	
	(B)=60mm		(E)=0.65 x 60				(D)=2.5mm x 10mm		(B)=C+Mn/6+(Cr+V+Mo)/5+(Cu+Ni)/15	
	(B)=55mm		(E)=0.65 x 55				(B)=7.5mm x 10mm		(C)=C-1/V/0.08+Si/24	
	(B)=56mm		(E)=0.65 x 56				(D)=0		(D)=0	

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED  
WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED *Amish Misra*  
QE & STALLURGIST

11 GA 1/2

## PT KRAKATAU STEEL (PERSERO)

**MILL CERTIFICATE**

PURCHASER : MARUBENI-ITOCHU STEEL CANADA INC.,  
METRO TOWER II, SUITE 710, 4720 KINGWAY, BURNABY, B.C.  
V5H 4N2, CANADA

COMMODITY : HOT ROLLED COIL

LC. NO. : 104-LCI-9061BB  
CERTIFICATE NO. : B F630207037630/MC/DM/1X/04  
DATE : SEPTEMBER01,2004  
LOT. NO. : 1  
DELIVERY ORD.NO.: 0007  
SUPPLIER ORD.NO.:  
ORDER NUMBER : F630207

SPECIFICATION : ASTM A 1011 CB TYPE B

P40518 ME005

PAGE 1 991 OF 993

RS/H904/023, ISSUE NO 1 03  
WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED ABOVE HAS BEEN TESTED  
AND COMPLIES WITH THE TERMS OF THE ORDER CONTRACT

DIVISION DE QUALITY CONTROL



CHIEF  
SUPERINTENDENT  
ACHMAD SAFI  
SCHOOL  
SUPERINTENDENT

**SUPERINTENDENT**

PHONE : (0234) 371015